

Work Order ID 71895

Wednesday, July 13, 2011 11:13:53 AM



Page 1

Item ID: D3443-3

Accept



Setup Start



Revision ID:

Item Name: Clevis

Stop



Start Date: 7/14/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: mf Date: 11-07-13

Tooling:

Date:

Run Start



QC: Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3443	Rev C
-------	-------

100

0.00



Doosan

Memo

0.00

Doosan Lathe

1-TURN AS PER FOLIO FA588 & DWG D3443

FOLIO REV: 11

DWG REV: 2

2-DEBURR AS REQUIRED

11.7.18

8

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

11.7.18

8

160

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

11/7/25

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71895

Wednesday, July 13, 2011 11:13:53 AM



Page 2

Item ID:	D3443-3	Accept		Setup	Start	
Revision ID:						
Item Name:	Clevis			Stop		
Start Date:	7/14/2011	Start Qty: 8.00				
Required Date:	7/28/2011	Req'd Qty: 8.00				
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 	Identify as per dwg & Stock Location: <u>WA21</u>	0.00							
Packaging	Memo	0.00							
Packaging	*****STOCK IN LARGE FAB*****								
180 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

PC 11-08-16

11/8/18

11-08-14
(Y)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, July 13, 2011 11:13:51 AM

Page 1

Work Order ID: 71895



Parent Item: D3443-3



Parent Item Name: Clevis


Start Date: 7/14/2011

Required Date: 7/28/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev: A ☐ 05.11.14 ☐ New issue ☐ EC ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R1.500  304 round bar 1.500		Purchased	No			100	f	11.8520	0.25	2			



25 11.7.14

Location

Loc Qty

Loc Code

MAT029

11.852

106260

0.272

114676 ✓

11.58

2.5 Lt

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

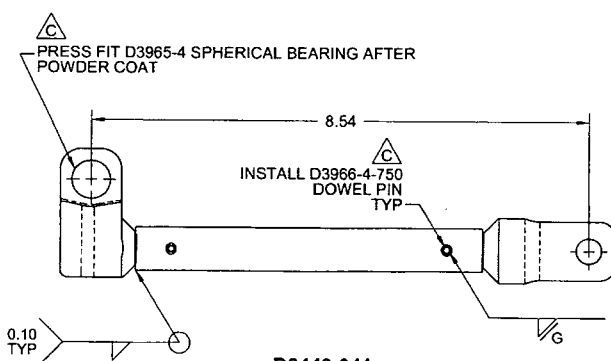
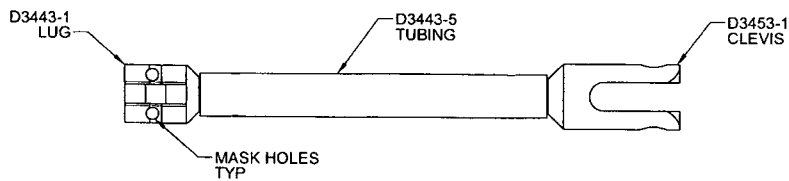
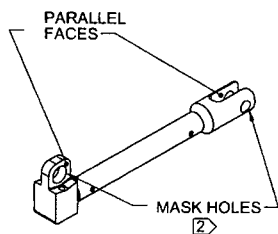
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3443-041

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.33 lbs
- 8) WELD PER DART QSI 004

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3443-041	STRUT WELDMENT ASSEMBLY
2	1	D3443-1	LUG
3	1	D3443-5	TUBING
4	1	D3453-1	CLEVIS
5	1	D3965-4	BEARING, SPHERICAL
6	2	D3966-4-750	PIN, DOWEL

C	DRAWING UPDATED TO CURRENT STANDARDS. REVISED NOTE #2 (ZN A5-1, A5-2); 0.820 WAS 0.720 & 1.43 WAS 1.53 (ZN C2-3); 0.551 WAS 0.451 (ZN C1-3); R0.219 WAS R0.050 (ZN C4-3); D3965-4 WAS SPAENAUER P/N (ZN C6-1, B5-2) D3966-4-750 WAS MCMMASTER-CARR P/N (ZN B5-1). REF PAR 09-018		RF	09.06.25
B	ADDED .8 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & 0.0.125 WAS #30		RF	05.12.05
A	NEW ISSUE		RF	05.09.02
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF	DRAWING NO. D3443		
CHECKED	RF	REV. C		
MFG. APPR.	RF	TITLE		
APPROVED	RF	SCALE		
DE APPR.	RF	STRUT WELDMENT ASSEMBLY NTS		
DATE	09.06.25	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		

71895

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09/06/25 MP

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

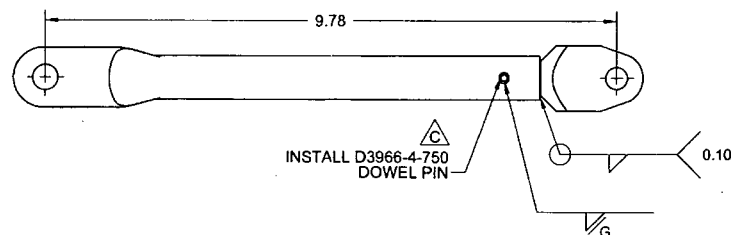
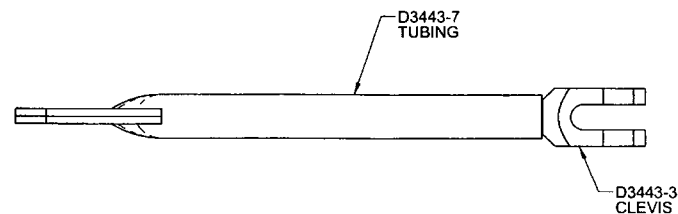
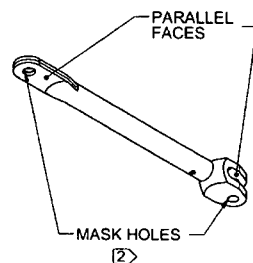
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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ITEM	QTY -043	P/N	DESCRIPTION
1	X	D3443-043	STRUT WELDMENT ASSEMBLY
2	1	D3443-3	CLEVIS
3	1	D3443-7	TUBING
4	1	D3966-4-750	PIN



D3443-043

71895

RELEASED
9/10/25/14

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.97 lbs
- 8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	UP	DRAWING NO.	REV. C
MFG. APPR.		D3443	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		STRUT WELDMENT ASSEMBLY	NTS
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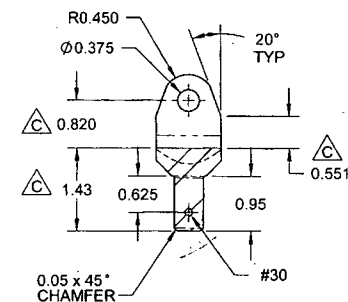
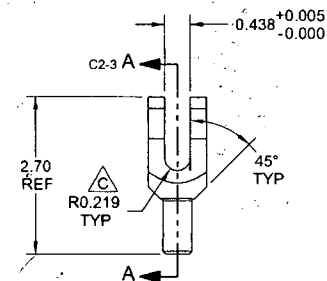
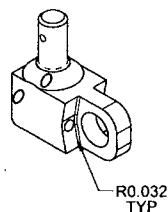
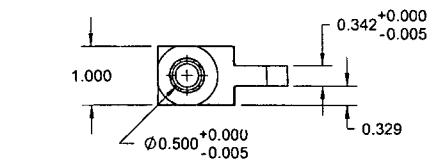
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

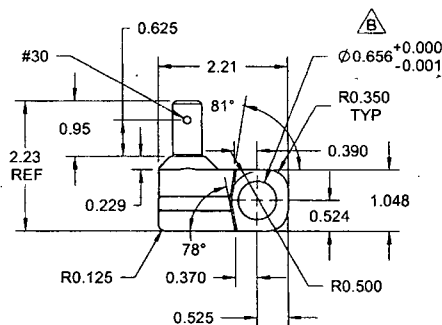
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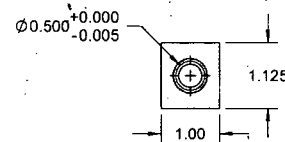
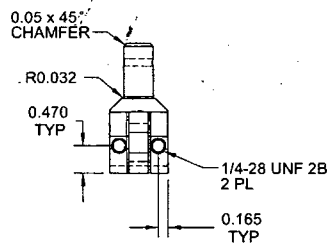
NOTE: Date & initial all entries



SECTION A-A C4-3



D3443-1 LUG



D3443-3 CLEVIS

NOTES:

- 1) MATERIAL: D3443-1 = 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)
D3443-3 = AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-1 = 0.50 lbs
D3443-3 = 0.35 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D3443	SHEET 3 OF 4
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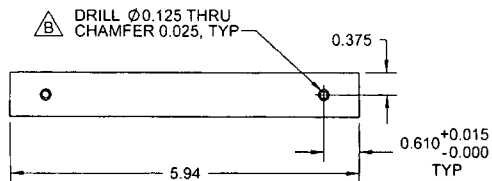
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

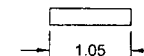
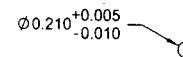
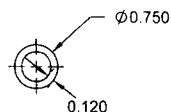
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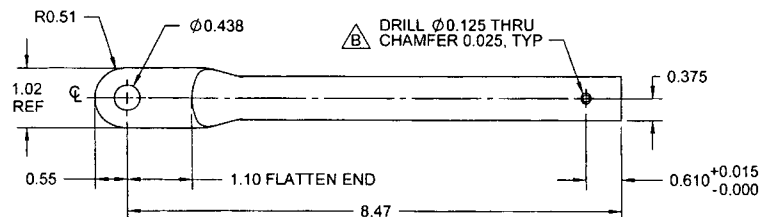
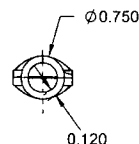
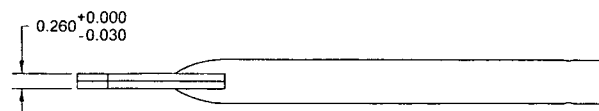
D3443-5 TUBING



D3443-9 PIN

D3443-9 NOTES:

- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A






D3443-7 TUBING

D3443-5/-7 NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.025 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-5 = 0.41 lbs
D3443-7 = 0.62 lbs

#71895

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09/06/25 MD

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.		D3443	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		STRUT WELDMENT ASSEMBLY NTS	
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D3065-5DART AEROSPACE LTD		Work Order: 71895
Description: Clevis		Part Number: D3443-3
Inspection Dwg: D3443	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.70	+/-0.030	2.706	/		RR .02	
0.95	+/-0.030	.947	/			
Ø0.500	+0.000/-0.005	.497	/			
20°	+/-0.5°	20°	/			
R0.450	+/-0.010	2.450	/			
Ø0.375	+0.006/-0.001	.378	/			
0.51	+/-0.010	.555	/			
0.625	+/-0.010	.626	/			
1.43	+/-0.030	1.430	/			
Ø0.820	+/-0.010	.823	/			
0.05 x 45°	+/-0.5°	.048 x 45°	/			
45°	+/-0.5°	45°	/			
1.00	+/-0.030	1.003	/			
1.125	+/-0.010	1.128	/			
0.438	+0.005/-0.000	.443	/			
R0.219	+/-0.010	R.219	/			

Measured by: RR
Date: 11.7.18

Audited by: SA
Date: 11/7/18

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.06.28	New Issue	KJ/JLM	
B	09.11.04	Dimensions updated per Dwg Rev C	KJ	M

Dart Aerospace Ltd

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
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NOTE: Date & initial all entries